

Work Order ID 67773

Wednesday, March 30, 2011 10:36:46 AM



Page 1

Item ID: D3490-1

Accept



Setup Start



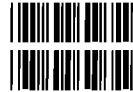
Revision ID:

Stop



Item Name: Cross Bolt Spacer

Start Date: 3/30/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 40.00

Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3490	Rev A

100 Hardinge CNC LATHE SMALL 0.00



Hardinge

Hardinge CNC Lathe Small

Memo

1-TURN AS PER FOLIO FA628 & DWG D3490

FOLIO REV: 1

DWG REV: 1

2-DEBURR AS REQUIRED

Handwritten: 11/4/07

Handwritten: 42 0

110 QC2- Inspect parts off machine FAI/FAIB 0.00



QC

Quality Control

Memo

Handwritten: 11/4/07

Handwritten: 42 0

120 QC8- Inspect parts - second check 0.00



QC

Quality Control

Memo

Handwritten: G.A 11/04/07

Handwritten: 42 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67773

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Page 2

Item ID: D3490-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Cross Bolt Spacer

Start Date: 3/30/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location:

WA

0.00



Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11.04.08

42 0 BE 11/04/11

11/04/11

MF 11-04-11

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Picklist Print

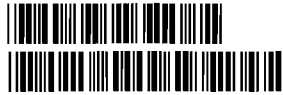
Wednesday, March 30, 2011 10:36:51 AM

Page 1

Work Order ID: 67773

Parent Item: D3490-1

Parent Item Name: Cross Bolt Spacer




Start Date: 3/30/2011

Required Date: 4/4/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 06-03-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.500W.049  6061-T6 RD Tube .500 x.049W		Purchased	No			100	f	0.0000	0.266	11.2			

 *114/7*

117270

12 Rt

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART AEROSPACE LTD		Work Order: 67773
Description: Crossbolt Spacer		Part Number: D3490-1
Inspection Dwg: D3490	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500	+0.006/-0.001	0.500	/		gag	
0.049	+/-0.010	0.048	/			
Ø0.402	+0.006/-0.001	0.405	/			
3.085	+0.030/-0.000	3.100	/			
0.050 x 45°	+/-0.010	0.050 x 45°	/			

Measured by: [Signature]	Audited by: B.A	Prototype Approval:	N/A
Date: 11/04/07	Date: 11/04/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.06	New Issue	KJ/JLM	
B	08.06.02	Dimensions and tolerances revised	KJ/DD	
C	08.10.07	0.050 x 45° dimension revised	KJ/DD	[Signature]

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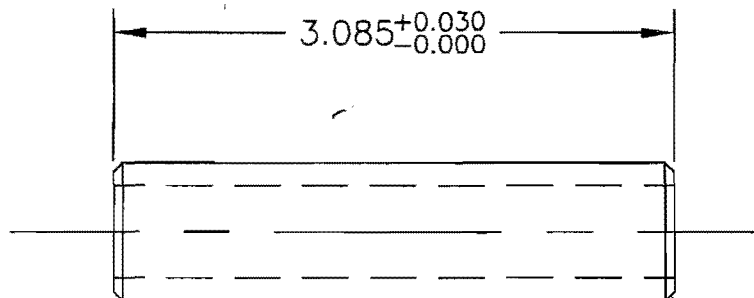
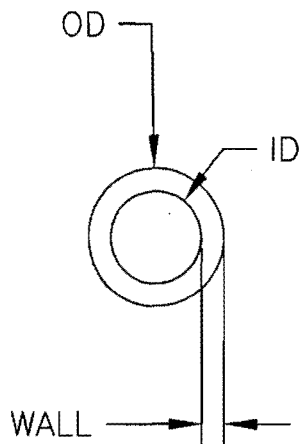
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DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS
A	06.01.04	NEW ISSUE	



0.050 X 45°
CHAMFER (TYP)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

Q1773 *PH* *11-03-90*

D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
do-02-07

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